

Date: Wednesday, 9/26/2007 2:09:08 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SEAT FRAME ASSEMBLY		
Job Number	: 34894					
Estimate Number	: 11122					
P.O. Number	:		Part Number	: D3016041		
This Issue	: 9/26/2007	S.O. No. :	Drawing Number	: D3016 REV A		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : LARGE FAB ASSY	Drawing Revision	: A		
Previous Run	: 33363		Material	:		
Written By	:		Due Date	: 10/15/2007 Qty: 1 Um: Each		
Checked & Approved By	:					
Comment	: Est. A 01.09.19 New issue EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M4130NT0750W049	4130 Tube .750 OD x.049W		
		Comment: Qty.: 6.8250 f(s)/Unit Total : 6.8250 f(s) 4130 Tube .750 OD x.049W Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall Batch: M100843		PD 08-04-11
2.0	M4130NT1000W049	4130 Tube 1.0"D X .049"W		
		Comment: Qty.: 2.6250 f(s)/Unit Total : 2.6250 f(s) 4130 Tube 1.0"D X .049"W Batch # M11591		PD 08-04-11
3.0	M4130NT0500W049	4130 Tube .500 OD x.049W		
		Comment: Qty.: 4.2000 f(s)/Unit Total : 4.2000 f(s) 4130 Tube .500 OD x.049W Cut- AISI 4130N tube, Ø1/2" x 0.049" wall Batch: M103789		PD 08-04-11
4.0	D301617	Gusset		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Gusset 2		
		Pick: Qty 12 Part Number D3016-17 Description Gusset Batch B22066		PD 08-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:09:08 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 34894

Part Number: D3016041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D301613 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket 2

Pick:

Qty Part Number Description Batch
1 D3016-13 Bracket 534208

PD 08-04-17

6.0 D301615 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset 2

Pick:

Qty Part Number Description Batch
1 D3016-15 Gusset 525762

PD 08-04-17

7.0 D30201 Fitting



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Fitting 4

Pick:

Qty Part Number Description Batch
2 D3020-1 Fitting B36713

PD 08-04-17

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/08/04/17

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Weld as per Dwg D3016

A/R Steel Rod Batch: 5100015
4130

4-Transfer Drill Holes to D3016-041 From D3021-041

PD 08-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:09:08 PM
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Process Sheet

30m w
18/04/2008
S.054 06.07
#1 325.7 F
B34894 F
D.3016041 F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 34894

Part Number: D3016041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AS 08/04/17

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/04/17

12.0 POWDER COATING

POWDER COATING



M 106442

Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

BL 08-04-18

(1)

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 08/04/23 (1)

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SB 08/04/23 (1)

15.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28 (1)

Job Completion



MF 08-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3016	SHEET 1 OF 3
DATE	TITLE		SCALE
01.05.18	SEAT FRAME ASSEMBLY		NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

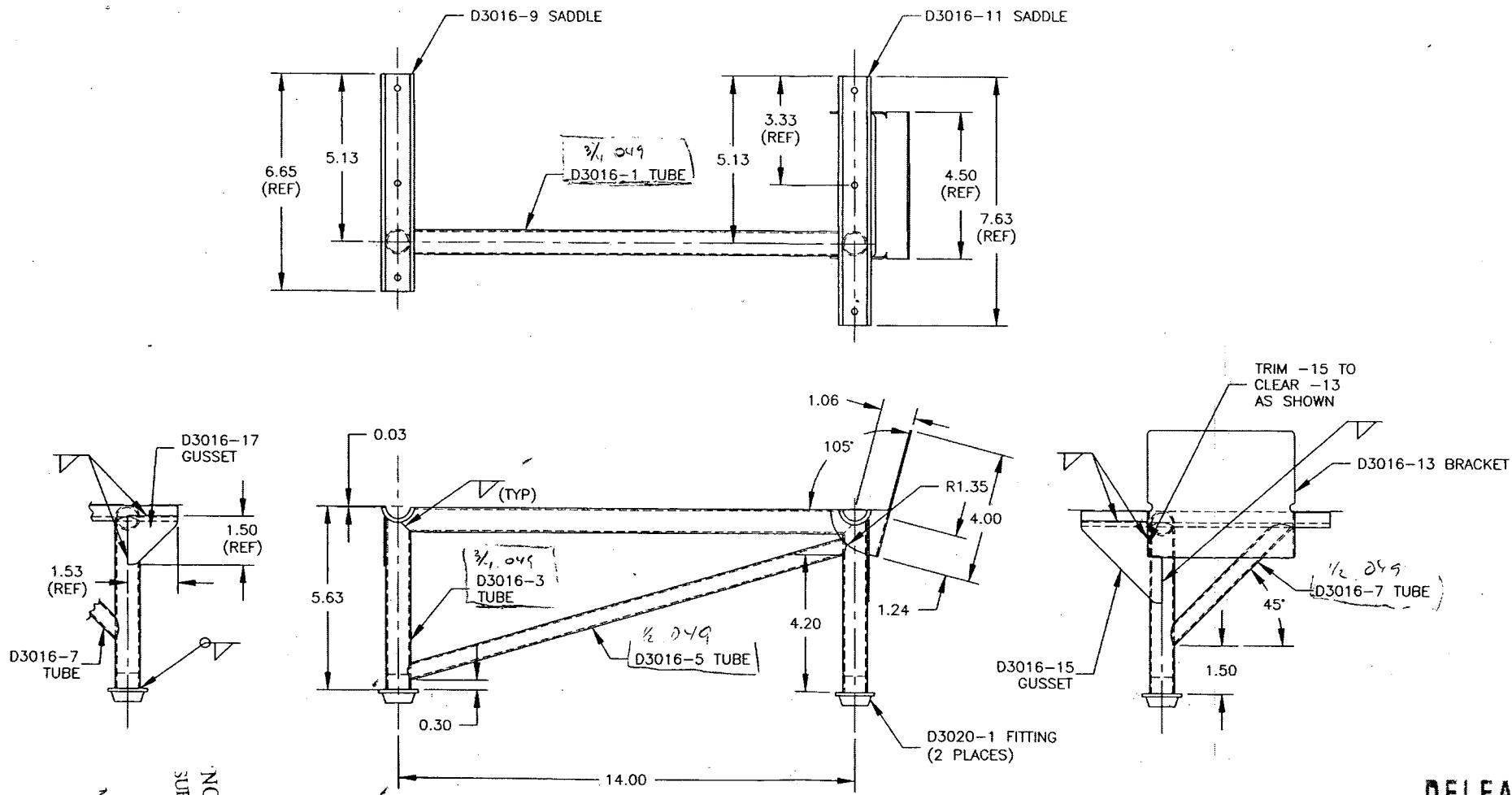
- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
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NO. 34894

RELEASED
01.05.30

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D3016-041 SEAT FRAME ASSEMBLYRELEASED
01-05-30

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CIP	CIP	APPROVED	DRAWING NO. D3016
DATE	01.05.18	REV. A	SHEET 2 OF 3 TITLE SEAT FRAME ASSEMBLY SCALE 1:3

